



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4271-025
Job Sheet 178114



Part No: D4271-025

Job Qty: 4 ea

Part Name: End Fitting Assembly Fwd Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 5/31/18

Created By: Marie Lajeunesse

Type: **SOLD**

Description:

Note: DWG REV D SHEET 2 IPP revA 11.07.20 new issue EC verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		5/31/18	0.00	0.00	Start Up Small Fab-3		5/31/2018
100	Small Fab	4 pcs		5/31/18	0.00	1.96	Small Fab-6		DAS 38
110	QC	4 pcs		5/31/18	0.00	0.00	QC5		38
120	Packaging	4 pcs		5/31/18	0.00	0.00	Packaging3-2		DAS 9-89
130	QC21-SA	4 Ea		5/31/18	0.00	0.00	QC21		21 18-06-18 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4C13A	Bolt	8 Ea (2 ea)	90-Start up Operation	5062293
D4149-5	Eyebolt Stud	4 Ea (1 ea)	90-Start up Operation	5055624
D4281-1	Spacer	4 Ea (1 ea)	90-Start up Operation	5023270
D4281-3	Spacer	4 Ea (1 ea)	90-Start up Operation	5063616
D4419-1	Fwd Support Plate	8 Ea (2 ea)	90-Start up Operation	5061032x16 (2X) 5073828
MS20427M4-20	Rivet	4 pcs (1 ea)	90-Start up Operation	5011845
MS20615-4M18	Rivet	40 Ea (10 ea)	90-Start up Operation	5011582
MS21043-4	Nut	8 Ea (2 ea)	90-Start up Operation	5056046
NAS1149C0432R	Washer	16 Ea (4 ea)	90-Start up Operation	5050062

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4C13A	8	83	0
	D4149-5	4	10	0
	D4281-1	4	6	0
	D4281-3	4	34	0
	D4419-1	8	10	0
	MS20427M4-20	4	32	0
	MS20615-4M18	40	106	0
	MS21043-4	8	916	0
	NAS1149C0432R	16	2,245	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____					
Description Work Order Deviation			Disposition						
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>			Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td style="width:50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>			Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
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OTHER : _____			Wrong Dimensions ☐ Tolerance ☐ Defect ☐ Missing ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐						

DART AEROSPACE
 Part: D4271-025
 Job No: 178114
 Serial No/Batch: S077513
 Revision: _____
 Inspector: _____
 Exp Date: 06/04/2018
 Instructions: _____



DART AEROSPACE
 Container No: S077513
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 TEL: 613 692-5200
 Email: sales@dartaero.com
 www.dartaero.com

Date: 06/04/18



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003515	S076151	AN4C13A	Bolt	s062293	ST344	8
003515	S076150	D4149-5	Eyebolt Stud	s055674	ST081	4
003515	S076149	D4281-1	Spacer	s023270	ST084	4
003515	S063616	D4281-3	Spacer	S063615	ST084	4
003515	S061032	D4419-1	Fwd Support Plate	S061033	ST090	6
003515	S076152	MS20427M4-20	Rivet	f118429	GA007	4
003515	S076148	MS20615-4M18	Rivet	s041582	ST306	40
003515	S076147	MS21043-4	Nut	s056040	ST302	8
003515	S076146	NAS1149C0432R	Washer	s050052	ST266	16

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

D4419-1 (X 2)

50 73 814

Plex 5/30/18 8:39 AM dart.quirion.sonia